

10/521938
DT01 Rec'd PCT/PTC 24 JAN 2005

U.S. Application No.: NEW
PRELIMINARY AMENDMENT

Attorney Docket: 3926.130

IN THE CLAIMS:

This listing of claims will replace all prior versions, and listings, of claims in the application.

1. (currently amended) A high-pressure die-cast cylinder crankcase, characterized wherein

~~in that~~ at least one continuous row (4) of at least two cylinder barrels (5) is cast into the cylinder crankcase (2),

the row of cylinder barrels (4) comprises a sand casting or chill casting,

the row of cylinder barrels (4) has at least one water jacket (6), and

the water jacket is being at least partially closed with respect to a side (18) of the cylinder crankcase (2) which faces a cylinder head.

2. (currently amended) A high-pressure die-cast cylinder crankcase, characterized wherein

~~in that~~ at least one continuous row (4) of at least two cylinder barrels (5) is cast into the cylinder crankcase (2),

the row of cylinder barrels (4) comprises a sand casting or chill casting,

the row of cylinder barrels (4) has at least one water jacket (6), and

the at least one cooling passage (10) of the water jacket (6) runs through the web region (12) between the cylinder barrels (5).

3. (currently amended) The high-pressure die-cast cylinder crankcase as claimed in claim 1 ~~or 2~~, ~~characterized in that wherein~~ the row of cylinder barrels (4) consists of an iron-based cast material.
4. (currently amended) The high-pressure die-cast cylinder crankcase as claimed in ~~one of claims~~ claim 1 to 3, ~~characterized in that wherein~~ the row of cylinder barrels (4) consists of a hypereutectic aluminum-silicon alloy.
5. (currently amended) The high-pressure die-cast cylinder crankcase as claimed in ~~one of claims~~ claim 1 to 4, ~~characterized in that wherein~~ the row of cylinder barrels (4) consists of a standard aluminum casting alloy, and a cylinder running surface is coated with a layer that is able to withstand frictional loads.
6. (currently amended) The high-pressure die-cast cylinder crankcase as claimed in claim 5, ~~characterized in that wherein~~ the layer is a thermally sprayed layer.
7. (currently amended) A process for producing the high-pressure die-cast cylinder crankcase wherein at least one continuous row (4) of at least two cylinder barrels (5) is cast into the cylinder crankcase (2),

the row of cylinder barrels (4) comprises a sand casting or chill casting,

the row of cylinder barrels (4) has at least one water jacket (6), and

the water jacket is at least partially closed with respect to a side (18) of the cylinder crankcase (2) which faces a cylinder head;

as claimed in claim 1 or 2, said process comprising the following steps:

casting a row of cylinder barrels (4) using a lost core so as to form an at least partially closed water jacket (6),

placing the row of cylinder barrels (4) into a high-pressure die-casting die of a cylinder crankcase (2), and

high-pressure die-casting the cylinder crankcase (2) and at the same time casting in the row of cylinder barrels (4).

8. (new) The high-pressure die-cast cylinder crankcase as claimed in claim 2, wherein the row of cylinder barrels (4) consists of an iron-based cast material.

9. (new) The high-pressure die-cast cylinder crankcase as claimed in claim 2, wherein the row of cylinder barrels (4) consists of a hypereutectic aluminum-silicon alloy.

10. (new) The high-pressure die-cast cylinder crankcase as claimed in claim 2, wherein the row of cylinder barrels (4) consists of a standard aluminum casting alloy, and a cylinder

running surface is coated with a layer that is able to withstand frictional loads.

11. (new) The high-pressure die-cast cylinder crankcase as claimed in claim 10, wherein the layer is a thermally sprayed layer.

12. (new) A process for producing the high-pressure die-cast cylinder crankcase wherein

at least one continuous row (4) of at least two cylinder barrels (5) is cast into the cylinder crankcase (2),

the row of cylinder barrels (4) comprises a sand casting or chill casting,

the row of cylinder barrels (4) has at least one water jacket (6), and

the at least one cooling passage (10) of the water jacket (6) runs through the web region (12) between the cylinder barrels (5);

said process comprising the following steps:

casting a row of cylinder barrels (4) using a lost core so as to form an at least partially closed water jacket (6),

placing the row of cylinder barrels (4) into a high-pressure die-casting die of a cylinder crankcase (2), and

high-pressure die-casting the cylinder crankcase (2) and at the same time casting in the row of cylinder barrels (4).